

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021033**Date Inspected:** 26-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Qui Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 008396

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13AW. The weld designations reviewed are as follows:

1. SEG3013AH-088, 091, 094, 097, 103, 104
2. SEG3013AH-041, 042, 043, 044

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020BB-111 located on Anchor plate to Vertical Shear Plate of OBG Segment 14W. ZPMC Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

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FCAW welding of weld joint SEG3020AA-019 and 020 located on Longitudinal Diaphragm Stiffener of OBG Segment 14W. ZPMC Welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133-ESAB.

FCAW welding of weld joint SEG3020Y-027 and 028 located on Longitudinal Diaphragm Stiffener of OBG Segment 14W. ZPMC Welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133-ESAB.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020E-053 located on Longitudinal Diaphragm to Floor Beam at Panel Point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2735R1.

SMAW welding of weld joint EP3020-001-107 located on Edge Plate of OBG Segment 14W. ZPMC Welder is identified as 067829. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint DP3126-001-139 1nd 140 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 204730. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-ESAB.

FCAW welding of weld joint DP3125-001-007, 014, 017, 022 and 025 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 204730. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on Vertical Plate to Bottom Plate 'T' joint at panel point 125 to 126 of OBG Segment 14W. The weld number is identified as SEG3020BB-010.

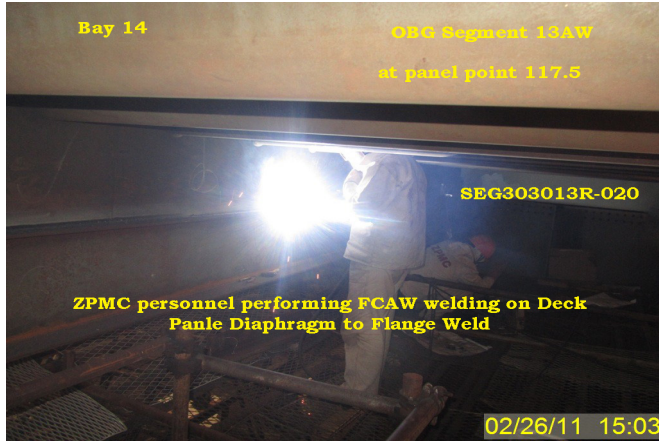
FCAW welding of weld joint DP3125-001-007, 014, 017, 022 and 025 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 204730. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG303013R-020 and 021 located on Deck Panel Diaphragm to Floor Beam at panel Point 117.5 of OBG Segment 13AW. ZPMC Welders are identified as 069469 and 068445. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer